MILITARY SPECIFICATION

BOLT, 180 KSI Ftu AND 108 KSI Fsu,
450°F PROTRUDING AND FLUSH HEAD,
GENERAL SPECIFICATION FOR

This amendment forms a part of Military Specification MIL-B-88318, dated 23 August 1982, and is approved for use by all Departments and Agencies of the Department of Defense.

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4.3 Delete and substitute: "4.3 Qualification inspections. The qualification inspections shall consist of the tests listed in 4.5. The number of samples for each test shall be three, except the carburization and nitrogenization test in which the number of samples shall be one."

TABLE VI. Delete in its entirety.

4.4 Delete and substitute: "4.4 Quality conformance inspections. The quality conformance inspections shall consist of the tests listed in 4.5, except for 4.5.3.3. Stress durability."

TABLE VIII. Delete in its entirety.

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Add 4.5.3.2.2.1 Shear strength (for sleeve bolts). The sleeve shall be removed and the bolt taper shall be ground to the smallest diameter before the test is conducted. The double shear strength test shall be conducted in accordance with MIL-STD-1312, Test 13.

4.5.3.2.3 Delete in its entirety and substitute the following paragraphs:

4.5.3.2.3 Fatigue strength. Bolts in accordance with MS14157, MS21134, and MS21250 shall be tested as specified in 4.5.3.2.3.2. Bolts having a grip length less than two times the diameter need not be fatigue tested, and acceptance for these bolts is on the basis of their tensile strength.

4.5.3.2.3.1 Fatigue strength (for sleeve bolts). The bolt with the expandable sleeve installed at the bolt head shall be used for this test. Cracks in the sleeve will not constitute failure of the bolt. Bolts having a grip length less than two times the diameter need not be fatigue tested, and acceptance for these bolts shall be on the basis of their tensile strength. Bolts shall be tested as specified in 4.5.3.2.3.2.

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4.5.3.2.3.2 Fatigue strength testing method. The method of testing and fixture requirements shall be in accordance with MIL-STD-1312, Test 11. The fatigue loading applied to bolts shall be tension-tension. The fatigue test shall be conducted at room temperature. The fatigue loading applied to the respective bolts shall conform to table IV.

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4.5.3.9 Change title to "4.5.3.9 Sleeve expansion (sleeve bolts only)."

Custodians:

Army - AV
Navy - AS
Air Force - 11

Preparing Activity:
Navy - AS

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